

Work Order ID 57430

April 7, 2010 8:16:18 AM



Page 1

Item ID: D3929-041

Accept



Setup Start

Revision ID:

Item Name: Gusset Assembly

Stop

Start Date: 07/04/2010 Start Qty: 6.00



Required Date: 14/04/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: PH Date: 10-4-07 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	Rev A								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3929 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
									(6)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

10-4-7

10-4-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M1052.13

(X6)

PD 10.04.08

(6) PD 10.04.08

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pl 10.04.08

160

QC5- Inspect part completeness to step on W/O

0.00



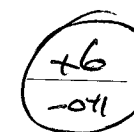
QC

Memo

0.00

Quality Control

Solobos



170

Identify as per dwg & Stock Location *Basket*

0.00



Packaging

Memo

0.00

Packaging

6 PD 10.04.08

Work Order ID 57430

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Cust Item ID:

Required Date: 14/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/04/12 *[Signature]*

ME
10-4-9

Picklist Print

April 7, 2010 8:16:22 AM

Page 1

Work Order ID: 57430

Parent Item: D3929-041

Parent Item Name: Gusset Assembly

Comments:

Start Date: 07/04/2010

Required Date: 14/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	40.3200	2.8421	3,		

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT19

112663

40.32

40.32

130

Each

83.0000

12.0000

1B 10-4-7

6

112663

D3907-1

Manufactured

No

Bushing

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

WA

83

55104

2

56517

40

57242

41

② PD 10.04.08
⑩ PD 10.04.08

8

7

6

5

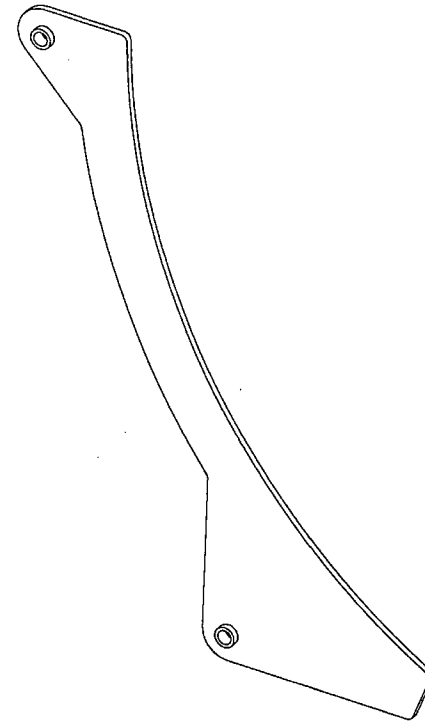
4

3

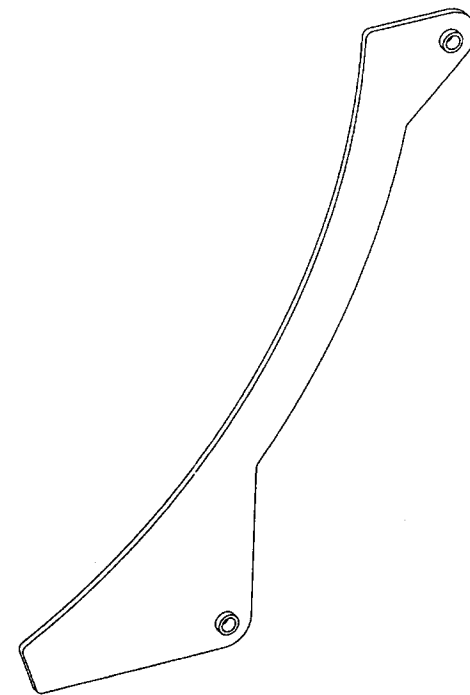
2

1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57430

10-4-07

RELEASED
8/10/04/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A		NEW ISSUE		MB		09.04.03	
REV.		DESCRIPTION		BY		DATE	
DESIGN		DART AEROSPACE LTD				REV. A	
DRAWN		HAWKESBURY, ONTARIO, CANADA				SHEET 1 OF 3	
CHECKED		DRAWING NO.				SCALE	
MFG. APPR.		D3929				NTS	
APPROVED		TITLE					
DE APPR.		GUSSET ASSEMBLY					
DATE		09.04.03					
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D3929-1
SUPPORT GUSSET
2 PL

0.25
2 PL, REF

D3907-1
BUSHING
2 PL

D3929-1
SUPPORT GUSSET
REF

D3929-041 GUSSET ASSEMBLY

D3929-1
SUPPORT GUSSET
2 PL

2 PL

D3907-1
BUSHING
2 PL

0.25
2 PL, REF

D3929-1
SUPPORT GUSSET
REF

D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED	AM	TITLE	SCALE
DE APPR.	TH	GUSSET ASSEMBLY	
DATE	09.04.03	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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